

Work Order ID 65178-2

Friday, January 07, 2011 9:04:25 AM

Page 1

Item ID: D3121-241

Accept

Revision ID:

Item Name: Bearing Assembly

Start Date: 1/10/2011 Start Qty: 30.00

Required Date: 1/17/2011 Req'd Qty: 30.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: 11-01-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn D3121-25 Cap as per Folio FA38712-Deburr

SA 11/01/10

31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/01/10

31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A. 11/01/11

31

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Page 2

Item ID: D3121-241

Accept



Setup Start



Revision ID:

Item Name: Bearing Assembly

Stop



Start Date: 1/10/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 1/17/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121								
				SB	11/01/21				
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Packaging	Identify as per dwg & Stock Location: 235A	0.00							
Packaging	Memo	0.00							

(7)

(7)

11/01/21 (7)

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Item ID: D3121-241

Accept



Setup Start



Revision ID:

Item Name: Bearing Assembly

Stop



Start Date: 1/10/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 1/17/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/26
ME

11-01-21

Picklist Print

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Page 1

Work Order ID: 65178

Parent Item: D3121-241

Parent Item Name: Bearing Assembly



Start Date: 1/10/2011

Required Date: 1/17/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 04.02.18 New issue: KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRINR1.000

Purchased

No

100

f

24.0000

0.052

1.56



Delrin Round Bar 1"



SA 11/01/10

Location

Loc Qty

Loc Code

MAT

24

116266

24

D3121-23

Manufactured

No

130

Each

37.0000

1

30



Bearing



1.24
EPB 11/01/11

Location

Loc Qty

Loc Code

ST235

37

56591

2

60708

1

64123

34

B65320

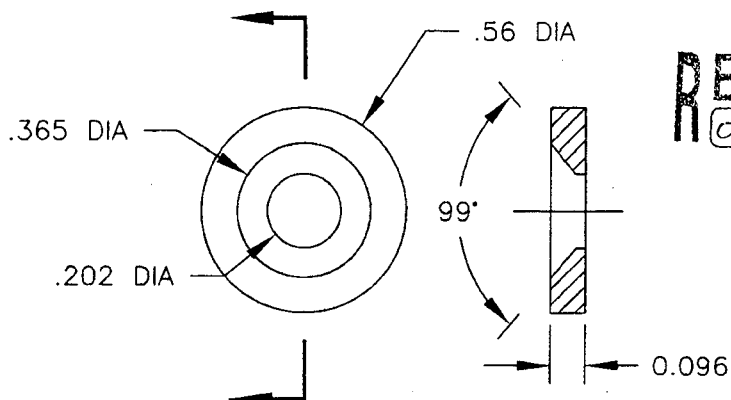
24

SA 11/01/21

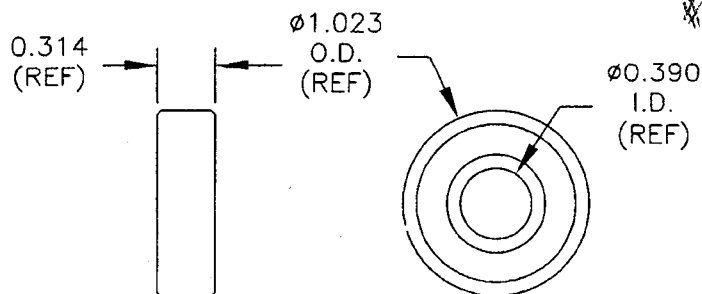
(J)

DART

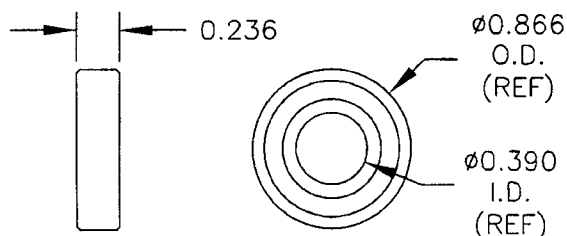
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

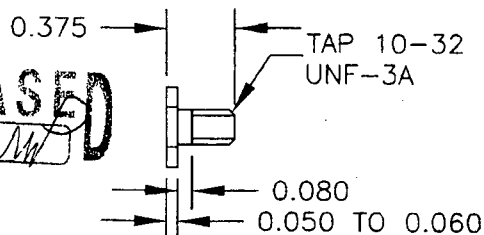
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

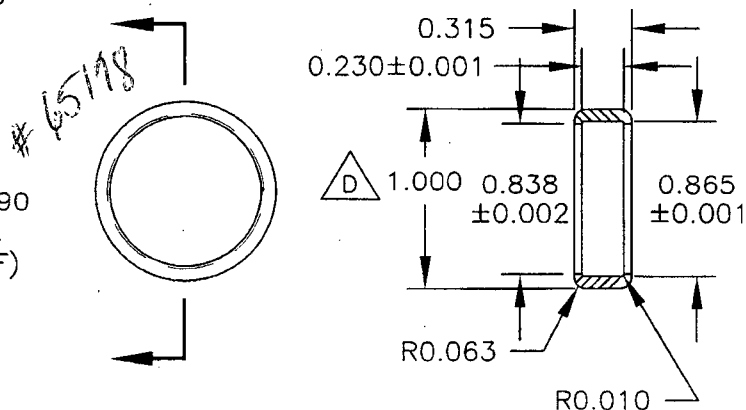
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

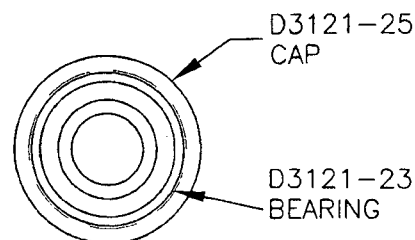
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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